



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

PRELIMINARY ISSUE

D5853-045

Job Sheet 207001



POSITIVE RECALL
EFFECTIVE 2007.14 AUTH
RELEASED 2007.14 DATE

Part No: D5853-045

Part Name: Lid Rim Weldment



Part Weight: 0 lbs

Job Created: 2/14/20

Due Date: 3/13/20

Type: Stock

Status: New

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: DWG D5853 Rev A IPP Rev. A 2020.01.30 New Issue DP Verify DD

Ship Via:

POSITIVE RECALL
EFFECTIVE _____ AUTH _____
RELEASED _____ DATE _____

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	12 pcs	3/13/20	0.00	2.40		Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 8		
							Large Fab - 11 (Various)		
							Large Fab - 12		
150	QC 9	12 pcs	3/13/20	0.00	0.00		QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
160	QC 5	12 pcs	3/13/20	0.00	0.00		QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



Container No: S256942



Part: D5853 - 045

Job No: 207001

Serial No/Batch: S256942

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/20/20

				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
170	Packaging 3-1 - Stock - B4B 12 pcs	3/13/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	DAS
				Packaging 3 - 19 - B4B	43
				Packaging 3 - 20 - B4B	9-08
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180	QC 21 - SA 12 pcs	3/13/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21

Part Op 100 - 1-Cut D5853-8 as per drawing. 2- Drill holes with DT10654 as per D5853-5 dwg 3-Deburr. 4-Weld as per drawing.
 Descriptions: 5-Back drill support as per drawing note 3.
 150 - (QC9- inspect visual per Q81004- Fusion Welds)
 160 - QC8- inspect part completeness to step on W/O
 170 - identify as per dwg & Stock Location: _____ As per drawing, see note 6.
 180 - QC21- Final Inspection - Work Order Release

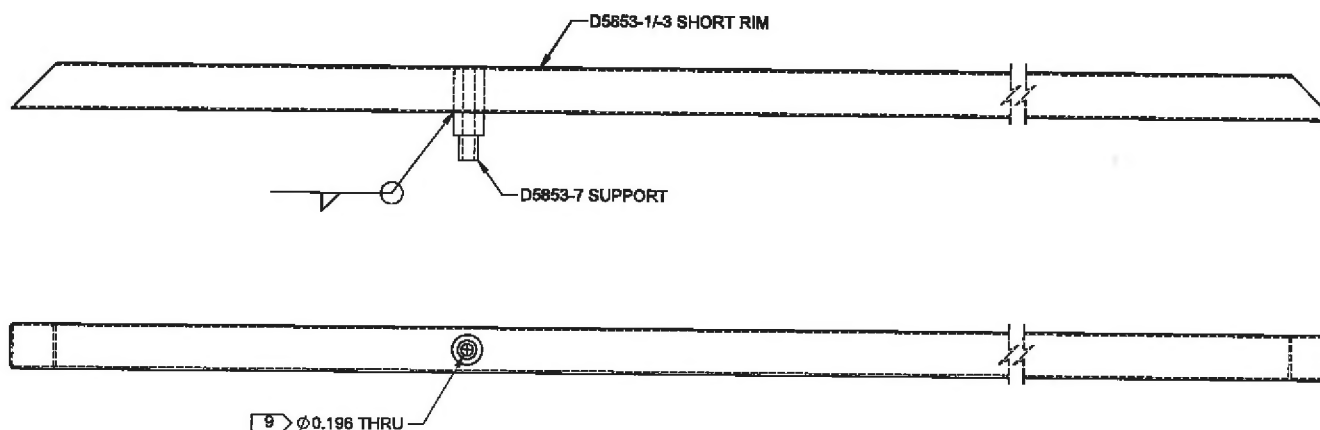
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4130NTS0.750W.035	4130 Square Tube 0.750 X 0.035W	22.8000 ft (1.9 ea)	100-Large Fab - Basket - 1	S250794
15853-9		24 (2 ea)		S259573

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	M4130NTS0.750W.035	23	609	0
Part Specifications				
Specifications could not be found.				

Plex 2/14/20 1:45 PM dart.lacelle.linda

QTY -041	QTY -043	P/N	DESCRIPTION
X		D5853-041	BASKET RIM WELDMENT
	X	D5853-043	BASKET RIM WELDMENT
1		D5853-1	SHORT RIM
	1	D5853-3	SHORT RIM
1	1	D5853-7	SUPPORT



D5853-041 BASKET RIM WELDMENT
D5853-043 BASKET RIM WELDMENT

PRELIMINARY ISSUE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND SERIAL NUMBER PER DART QSI 044 6.6
- 7) WEIGHT: -041: 0.65 lbs
-043: 0.73 lbs
- 8) WELD PER DART QSI 004
- 9) DRILL THRU SUPPORT AND TUBE AFTER WELDING.

PRELIMINARY ISSUE

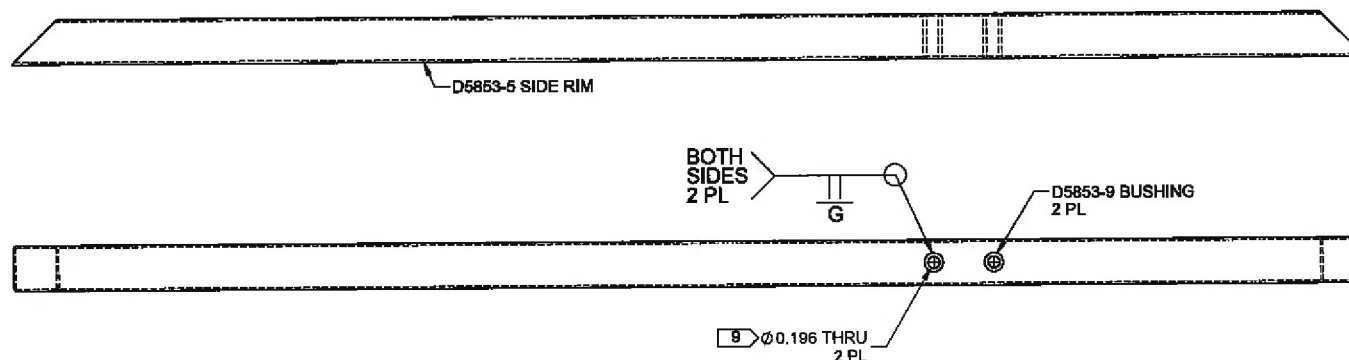
REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	ZF	20.01.24
DESIGN	ZF		
DRAWN	ZF		
CHECKED	KPT		
MFG. APPR.	DD		
APPROVED			
DE APPR.			
DATE	20.01.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5853** REV. A2
SHEET 1 OF 6
TITLE **BASKET RIM** SCALE NTS

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QTY -046	P/N	DESCRIPTION
X	D5853-046	LID RIM WELDMENT
1	D5853-5	SIDE RIM
2	D5853-9	BUSHING



D5853-045 LID RIM WELDMENT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND SERIAL NUMBER PER DART QSI 044 6.6
- 7) WEIGHT: 0.81 lbs
- 8) WELD PER DART QSI 004
- 9) DRILL THRU BUSHINGS AFTER WELDING.

PRELIMINARY ISSUE

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A2
MFG. APPR.	DD	D5853	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		BASKET RIM	NTS
DATE	20.01.24	<small>COPYRIGHT © 2020 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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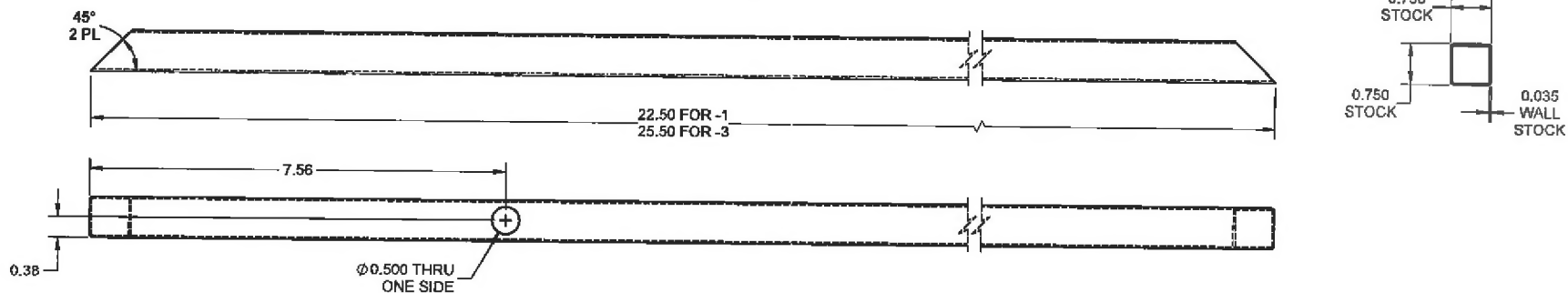
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D5853-1 SHORT RIM
D5853-3 SHORT RIM

PRELIMINARY ISSUE

NOTES:

- 1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 3/4 X 0.035 WALL
PER MIL-T-6736 OR AMS 6371/6370/6361/6362/6373/6374
REF DART SPEC M4130N-TS
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -1: 0.59 lbs
-3: 0.68 lbs

PRELIMINARY ISSUE

DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	KPT	DRAWING NO.	REV. A2
MFG. APPR.	DD	D5853	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		BASKET RIM	NTS
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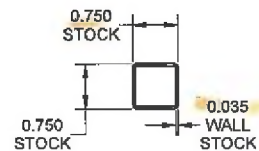
22.60

15.31

1.000

Ø 0.313 THRU
BOTH SIDES
2 PL

0.38

**D5853-5 SIDE RIM****NOTES:**

- 1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 3/4 X 0.035 WALL
PER MIL-T-6738 OR AMS 6371/6370/6361/6362/6373/6374
REF DART SPEC M4130N-TS
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.59 lbs

PRELIMINARY ISSUE

PRELIMINARY ISSUE

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A2
MFG. APPR.	DD	D5853	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		BASKET RIM	NTS
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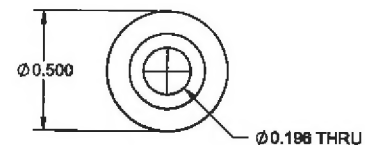
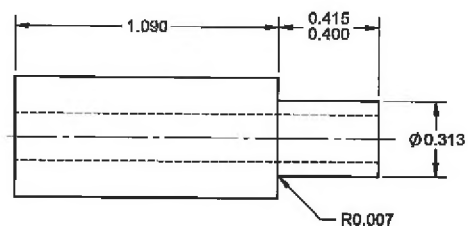
5

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D5853-7 SUPPORT
(DERIVED FROM AERO DESIGN P/N 70422-05)

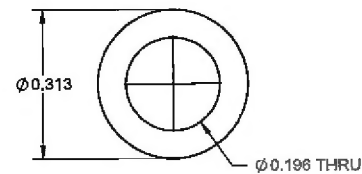
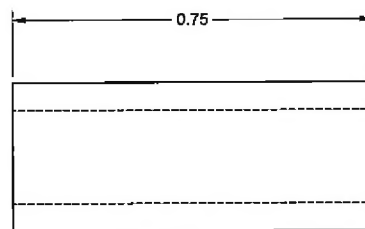
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
PER ASTM A276 OR ASTM A479
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.08 lbs

PRELIMINARY ISSUE

PRELIMINARY ISSUE

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A2
MFG. APPR.	DD	D5853	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		BASKET RIM	NTS
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D5853-9 BUSHING
(DERIVED FROM AERO DESIGN P/N 70422-04)

NOTES:

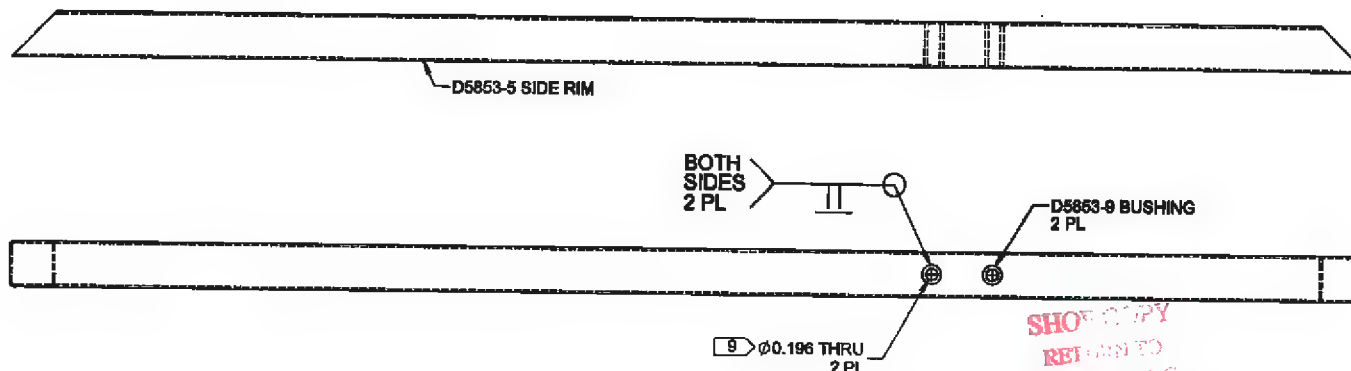
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBE, 5/16 OD X 0.058 WALL
PER ASTM A213 OR ASME SA213 OR ASTM A268
REF DART SPEC M304TR
OR
AISI 304/316 STAINLESS STEEL ROUND BAR
PER ASTM A276 OR ASTM A479
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

PRELIMINARY ISSUE

DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	KPT	DRAWING NO.	REV. A2
MFG. APPR.	DD	D5853	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		BASKET RIM	NTS
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PRELIMINARY ISSUE

QTY -045	P/N	DESCRIPTION
X	D5853-045	LID RIM WELDMENT
1	D5853-5	SIDE RIM
2	D5853-9	BUSHING



SHOW COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITH NO FORCE
WORK ORDER
NO. 207001

115
20-02-20

UNDER REVIEW
URF 2020-522 20.02.14 (NO)

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY PER DART QSI 044
7) WEIGHT: 0.61 lbs.
8) WELD PER DART QSI 004. GRIND WELDS FLUSH IF REQUIRED.
9) DRILL THRU BUSHINGS AFTER WELDING.

RELEASED
2020 FEB 18 NQ

APPROVED

DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A SHEET 2 OF 6 SCALE NTS
DRAWN	ZF		
CHECKED	KPT		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	CP	DRAWING NO. D5853	TITLE BASKET RIM
DATE	20.01.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES AND COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045594



Supplier: FAC001-VU
Factory Steel
14020 Oakland Ave.
Detroit, MI 48203 USA
Phone: 313 883 6300
Fax: 313 883 4883

PO No: POHB045594

PO Date: 1/16/20

Due Date: 2/4/20

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

JAN 16 2020

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1		M4130NTS1.000W.035			4130 Square Tube 0.750 X 0.035W : MATERIAL: AISI 4130N STEEL SQUARE TUBING PER ONE OF THE FOLLOWING SPEC'S: MIL-T-6736, AMS 6371, 6390, 6361, 6362, 6373 OR 6374	Firmed	-	2/4/20	600 ft	0 ft	600 ft	\$7.25/ft	\$4,350.00
2		M4130NTS1.000W.065			4130 Square Tube 1.000" X 1.000" X 0.065"W : MATERIAL: AISI 4130N STEEL SQUARE TUBING PER ONE OF THE FOLLOWING SPEC'S: MIL-T-6736, AMS 6371, 6390, 6361, 6362, 6373 OR 6374	Firmed	-	2/4/20	160 ft	0 ft	160 ft	\$11.70/ft	\$1,872.00

Grand Total: \$6,222.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045594



Order Notes

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable). No Raw Metals from China or Soviet Bloc Countries. (DFARS)

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program.

A049 supplier awareness.

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/16/20 11:38 AM Dart.Lavoie.Chantal

PACKING LIST

No. 67371

PG 1 OF 1

PL

FACTORY STEEL & METAL SUPPLY 14020 OAKLAND AVENUE DETROIT, MI 48203		CUSTOMER PO POHB045594		BUYER CHANTEL LAVOIE Tel (613) 632-3336 Fax (613) 632-4443		SHIP DATE 01/21/2020	
(313)883-6300 PHONE (313)883-4883 FAX		CUSTOMER JOB				SHIP VIA ****TRUCK****	
		SALES ORDER 60306		ORDER DATE 01/16/2020		SALES REP MICK HALON	
						RESALE # 59-2958719	
SOLD TO DART AEROSPACE 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7		SHIP TO DART AEROSPACE 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7		SHIP INST CALL WHEN READY		CARRIER TRUCK	
				PRO#		BLIND Y/N N	
				TERMS NET 30 DAYS		FOB DETROIT	

LINE	QUANTITY	DESCRIPTION	WIDTH	LENGTH	WEIGHT		
1	609.917 FT	4130N CD SMLSS SQ TUBE 3/4" X .035W		20'/24' RL	207.554		
		Tag Mill Ref # Heat	Pcs Length	Feet	Weight		
		153513 023679 616506	26 20'/24' RL	609.917	207.554		
2	171.333 FT	4130W CD SMLSS SQ TUBE 1" X .065W		22'/23' RL	141.606		
		Tag Mill Ref # Heat	Pcs Length	Feet	Weight		
		153514 072143 072067859	7 22'/23' RL	171.333	141.606		
3	1 PCS	PACKING CHARGES					
		MTRS (CIRCLE) FAX SHIPMENT INVOICE ALL					
		DATE: _____ INITIAL: _____					

TOTAL WT 349 LBS							
RECEIVED BY - SIGNATURE		RECEIVED BY - PRINTED NAME		DATE RECEIVED			

SO

M4130NTS0.750W.035

616506



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. M4130N-TS	REV. A SHEET 1 OF 1
DATE 05.02.09		TITLE 4130N SQUARE TUBING	SCALE NTS
A	05.02.09	NEW ISSUE	

PURCHASE MATERIAL:

AISI 4130N STEEL SQUARE TUBING PER ONE OF
THE FOLLOWING SPEC'S: MIL-T-6736, AMS 6371,
6360, 6361, 6362, 6373 OR 6374

DAS
82
9-89

PART NUMBER:

M4130N-TS | A.AAA | W | .TTT |

WHERE A.AAA = WIDTH IN INCHES
TTT = WALL THICKNESS IN INCHES

EXAMPLE: 0.50" X 0.035" WALL = M4130N-TS0.500W.035

05-03-05 [Signature]

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PLYMOUTH TUBE CO.

1209 East 12th Street, Streator, Illinois 61355

Phone: (815) 477-1616 Fax: (815) 477-7178

TRUST NO ONE. SOURCE MATTER NO SUBSTITUTION



PRODUCT CERTIFICATION

SALES ORDER - LINE / RLS

175629 - 1 / 0

SHIP TO

Factory Steel & Metal Supply C
14020 Oakland Avenue
Detroit, MI 48203
USA

WORK ORDER 023679

HEAT NUMBER 616506

MELT SOURCE Bencker Steel & Tube-Germany

PCS/HEAT

0

CUSTOMER P.O. 3887	CUSTOMER PART SQ-N34035	QUANTITY	LADING NO	CERT ID / REV /	CERT DATE								
PART DESCRIPTION SHSQ0750035J300 ***** Square OD ***** Side1: 0.7600 Max:0.7600 Min:0.7400 Side2: 0.7600 Max:0.7600 Min:0.7400 Wall: 0.0360 Max:0.0380 Min:0.0320 Length: 18.00 Spec: 4130 Grade: 4130 Annex: Cond N													
CERTIFICATION REQUIREMENTS FAR BAA (FAR 52.225-5 Trade Agreements Act Supplies), DFARS 252.225-7001 By America Act & Bal. of Payments Program FAR TAA (FAR 52.225-5 Trade Agreements Act), Paragraph 1.4.5 This material was Eddy Current tested and conforms to the requirements of ASTM A-450. The Grain size is determined and reported by the raw material supplier in accordance to ASTM E-112. This raw material was magnetic particle inspected by the raw material supplier in accordance to AMS 7842 and/or ASTM E-1444, and rated as Frequency and Severity to AMS 2301, latest revision. Yield is determined by using the 0.2% offset method and specifications - AMS-T 6736B, 6360P & 6371L. Material produced in accordance to ASTM A-519-17 and MIL-T 6738B. This material meets Plymouth ProMoly specifications. Jominy results: J(5/16")=45 J(8/16")=38													
Chemical Analysis													
C	Mn	P	S	Si	Al	Cr	Mo	Ni	Pb	Cu	V	Ti	Sn
.310	.15	.011	.002	.230	.036	.87	.18	.12	.001	.16	.002	.002	.010
Physical Properties													
Freq.	Severity	Grain Size											
.020	.015	9											
Mechanical Properties													
TEST	UNITS	#TESTS	HIGH	LOW	AVERAGE	STD-DEV							
Tensile	Psi	6	126660	125480	126065	482							
Yield	Psi	6	120930	119880	120387	374							
Elongation	%	6	21	20	20	1							
Rockwell C	Rc	6	25	25	25	0							
TEST	RESULT												
Decarb/Ot	Pass												
Total ID/OD decarb	Pass												

I certify that the results are true and correct copy of the records prepared and maintained by Plymouth Tube Company, Streator in compliance with the requirements of the cited specification. Chemistry is as reported by the Steel supplier. This test report cannot be reproduced or distributed except in full without the written permission of Plymouth Tube.

James J. Saff

Quality Assurance



PLYMOUTH TUBE CO.

1200 E. 12th St., St. Clair, MI 48089
Phone (810) 478-4116 Fax (810) 478-4117

PLEASE NOTE: ALL INFORMATION IS SUBJECT TO CHANGE WITHOUT NOTICE

PRODUCT CERTIFICATION

SALES ORDER - LINE / RLS

173528 - 1 / 0

WORK ORDER 023879

PCS/HEAT 0

HEAT NUMBER 616506

MELT SOURCE Böhler Steel & Tube-Germany

SHIP TO

Factory Steel & Metal Supply C
14020 Oakland Avenue
Detroit, MI 48203
USA

CUSTOMER P.O. 3887	CUSTOMER PART SQ-N34035	QUANTITY	LOADING NO	CERT ID / REV /	CERT DATE
PART DESCRIPTION SHSQ0750035J300					
Additional Specification(s)					
<u>TEST</u> Brinell	<u>UNITS</u> Brinell	<u>TESTS</u> 6	<u>HIGH</u> 253	<u>LOW</u> 253	<u>AVERAGE</u> 253
					<u>STD-DEV</u> 0
<p>This test report data is for the heat Chemistry Stated above.</p> <p>The material in this test report is:</p> <ol style="list-style-type: none"> 1) Drawn in the USA 2) Free from Polybrominated Biphenyls (PBB), Polybrominated Diphenyl Ethers (PBDE), and Mercury contamination. 3) N/AFTA compliant. <p>End of Certification</p>					

I certify that the results are a true and correct copy of the records prepared and maintained by Plymouth Tube Company, created in compliance with the requirements of the cited specification. Chemistry is as reported by the Steel supplier. This test report cannot be reproduced or distributed except in full without the written permission of Plymouth Tube.

Janine Buresett
Quality Assurance

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M4130NTS 0.750W .035 PO / BATCH NO.: POMB 045594
 DATE: JAN 27 2020 5250794

MATERIAL CERT REC'D: YES
 QUANTITY RECEIVED: 609 PL
 QUANTITY INSPECTED: 609 PL
 QUANTITY REJECTED: 0

THICKNESS ORDERED: .750 W .035
 THICKNESS RECEIVED: .750 W .035
 SHEET SIZE ORDERED: —
 SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y (N)	
CORRECT FINISH	(Y) N	
CORROSION	Y (N)	
CORRECT GRAIN DIRECTION	(Y) N	
CORRECT MATERIAL PER M-DRAWING	(Y) N	MIL-T-6736
CORRECT THICKNESS	(Y) N	
PHOTO REQUIRED	Y (N)	
CORRECT REF # TO LINK CERT	(Y) N	666506
CORRECT MATERIAL IDENTIFICATION	(Y) N	
CORRECT M# ON THE MATERIAL	(Y) N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y (Y)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y (N)	

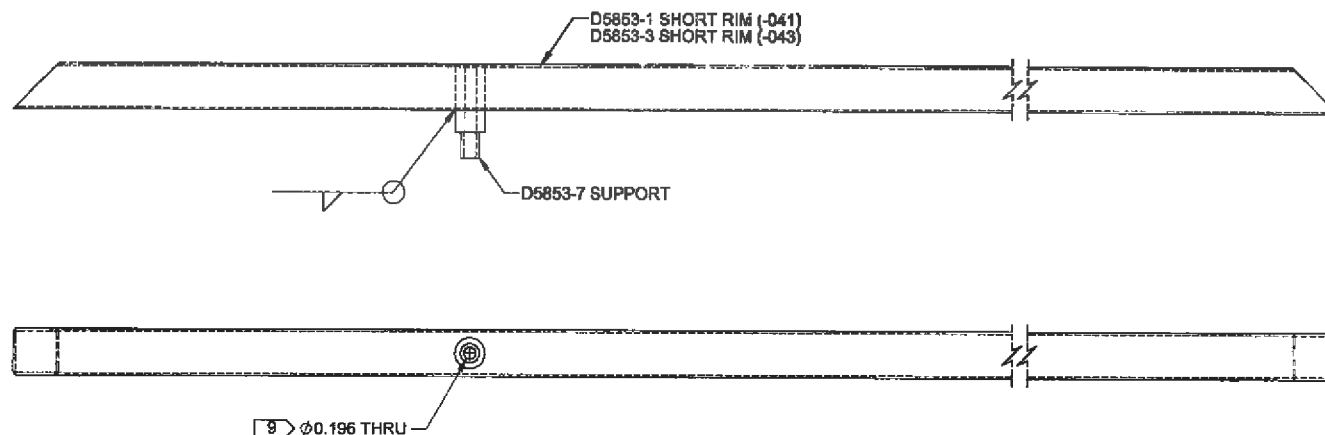
CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL SIZE OF TEST SAMPLE HARDNESS / DUROMETER READING	HRC	HRB	DUR A	DUR D	WEBSTER

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: _____	DAS	SIGNED OFF BY: _____	
DATE: <u>JAN 27 2020</u>	<u>32</u> 9.89	DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

QTY -041	QTY -043	PN	DESCRIPTION
X		D5853-041	BASKET RIM WELDMENT
	X	D5853-043	BASKET RIM WELDMENT
		D5853-1	SHORT RIM
		D5853-3	SHORT RIM
		D5853-7	SUPPORT



D5853-041 BASKET RIM WELDMENT
D5853-043 BASKET RIM WELDMENT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: -041: 0.85 lbs
-043: 0.73 lbs
- 8) WELD PER DART QSI 004
- 9) DRILL THRU SUPPORT AND TUBE AFTER WELDING.

RELEASED

2020 FEB 18 W/D
ECN 2020-521

APPROVED

UNDER REVIEW
URF 2020-522 20.02.14 (NO)

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	ZF	20.01.24
DESIGN	ZF		
DRAWN	ZF		
CHECKED	KPT		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	CP		
DATE	20.01.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D5853

TITLE

BASKET RIM

REV. A

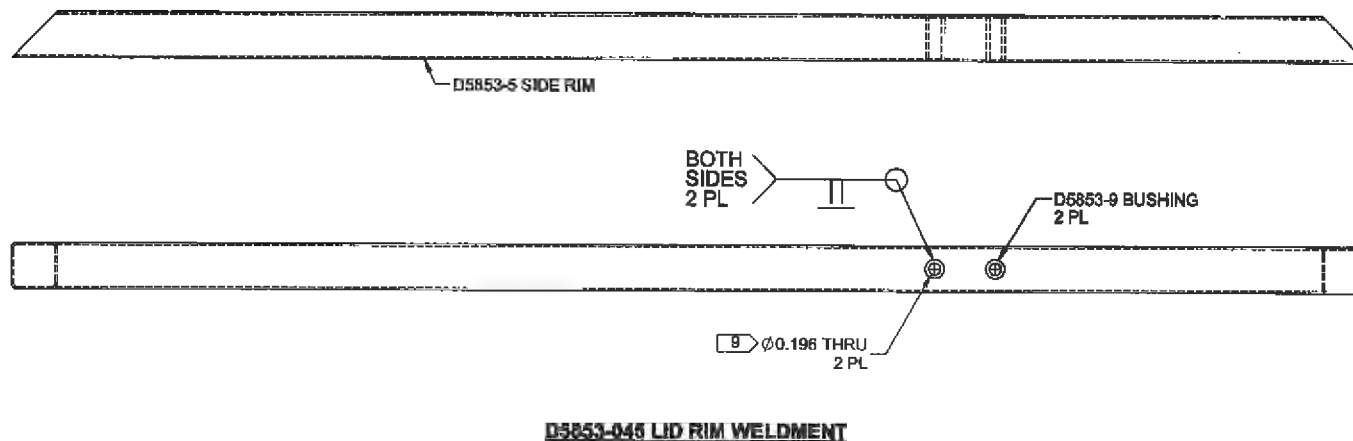
SHEET 1 OF 6

SCALE

NTS

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QTY 045	P/N	DESCRIPTION
Y	D5853-045	LID RIM WELDMENT
1	D5853-5	SIDE RIM
2	D5853-9	BUSHING



UNDER REVIEW
URF 2020-522 20.02.14 (NO)

NOTES:

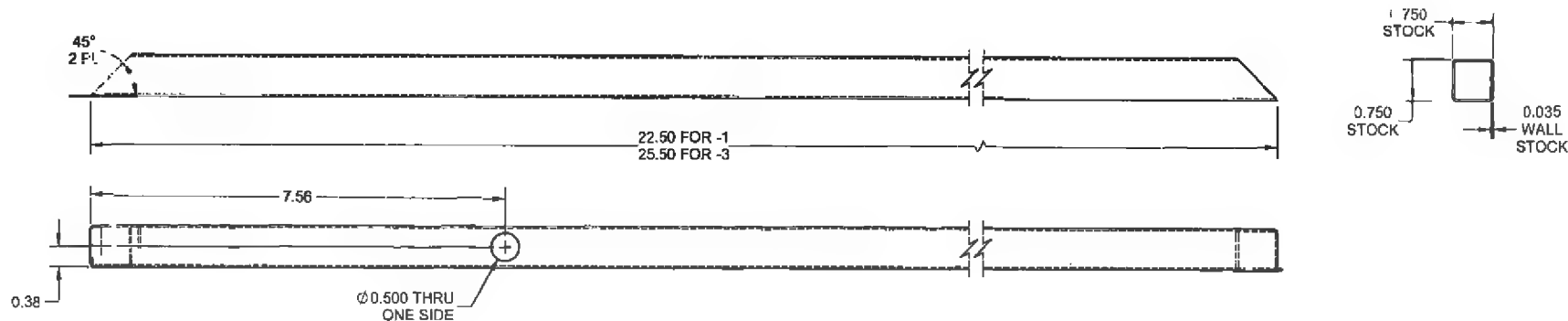
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: 0.61 lbs.
- 8) WELD PER DART QSI 004. GRIND WELDS FLUSH IF REQUIRED.
- 9) DRILL THRU BUSHINGS AFTER WELDING.

RELEASED
2020 FEB 18 *NG*

APPROVED

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5853	SHEET 2 OF 6
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	BASKET RIM	NTS
DATE	20.01.24	COPYRIGHT © 2020 BY DART AEROSPACE LTD	

8 7 6 5 4 3 2 1



D5853-1 SHORT RIM
D5853-3 SHORT RIM

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

NOTES:

- 1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 3/4 X 0.035 WALL
PER MIL-T-6736 OR AMS 6371/6360/6361/6362/6373/6374
REF DART SPEC M4130N-TS
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -1: 0.59 lbs
-3: 0.68 lbs

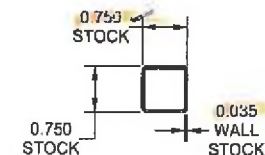
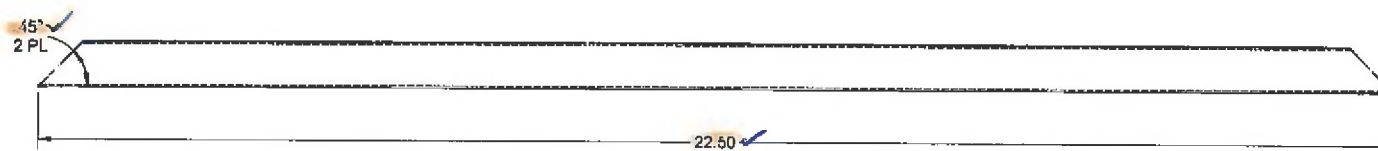
RELEASED
2020 FEB 18 *Wd*

APPROVED

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5853	SHEET 3 OF 8
APPROVED	NO	TITLE	SCALE
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D5853-5 SIDE RIM

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

NOTES:

- 1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 3/4 X 0.035 WALL
PER MIL-T-6736 OR AMS 6371/6360/6361/6362/6373/6374
REF DART SPEC M4130N-TS
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.59 lbs

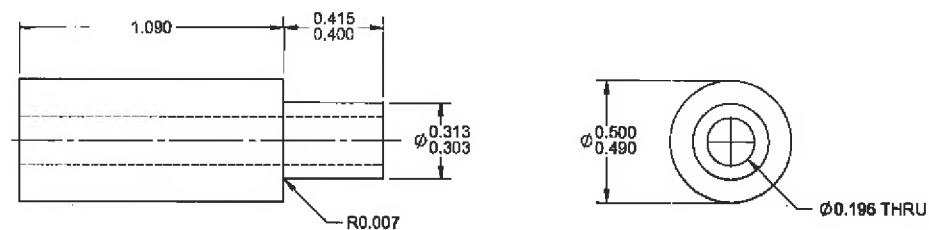
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2020 FEB 18 NO

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CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5853	SHEET 4 OF 6
APPROVED	NO	TITLE	SCALE
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8 7 6 5 4 3 2 1



D5853-7 SUPPORT
(DERIVED FROM AERO DESIGN P/N 70422-05)

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

NOTES:

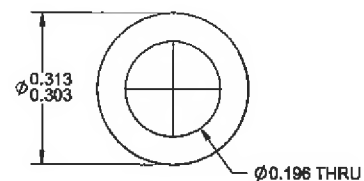
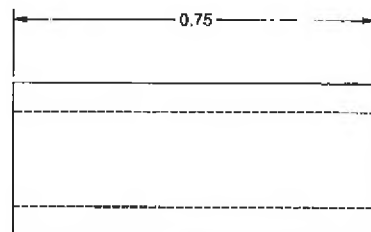
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
PER ASTM A276 OR ASTM A479
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs

RELEASED

2020 FEB 18 WQ

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DESIGN	ZF	DART AEROSPACE LTD	
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CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5853	SHEET 5 OF 6
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D5853-0 BUSHING
(DERIVED FROM AERO DESIGN P/N 70422-04)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
PER ASTM A276 OR ASTM A479
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

RELEASED

20 FEB 18

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DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5853	SHEET 6 OF 6
APPROVED	NO	TITLE	SCALE
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ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 2020.02.14	Job No.: Aero2019	ADR Yes/No: N	ADR Date:	ECN #: 2020 521
Product No.: D350-1080 baskets		Created By: NO	Approved By: <i>UP</i>	
Product Name: Quick Release Cargo Baskets		Checked By:		

Reason for Change:
D350-1080 Baskets Limited Release #1

Documents Released:
D5785 at Rev A, D6795 at Rev A, D5794 at Rev A, D5770 at Rev A, D5815 at Rev A, M304 TS at Rev E, M3003H22TP at Rev A, D5806 at Rev A, M302SW at Rev B
D5759 at Rev A, D5805 at Rev A, D5803 at Rev A, D5853 at Rev A, D5765 at Rev A, D5760 at Rev A, D5761 at Rev A, D5802 at Rev A, D5808 at Rev A, D5810 at Rev A.

IF APPLICABLE: NCR: PAR: CAR: CIR: URF: 2020-522

PAPERWORK UPDATE ☒ PARTS MUST COMPLY ☐ PREVIOUS PARTS SATISFACTORY ☒

#	Quality Assurance / Customer Support Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Airbus	N			
3	Notify Learjet	N			
4	Manufacturing Licensing Agreement Update	N			

#	Engineering Actions	Reqd	Resp	Notes	Complete
6	Required Documents/ Drawings/Item ID's Under Review (URF)	Y	NO	ALL RELEASED PARTS PLACED UNDER REVIEW	<i>met 20.02.18</i>
6	Update Master Document List (MDL)	N		NO MDL/STC FOR THESE PARTS AT THIS TIME	
7	Update Document Record (DR)	N			
8	Update Product Competability Matrix	N			
9	Notify TC / FAA of Change (eg. ICA, 8110-3)	N			
10					

#	Document Control Actions	Reqd	Resp	Notes	Complete
11	Move / Update Electronic Files / Design Journal	Y	MG		<i>met 20.02.18</i>
12	Update Product Specification Files (Bluefiles)	N			
13	Update Approved/Preliminary Dwg PDF Files	Y	MG		<i>met 20.02.18</i>
14	Update Product Development Summary (STC applications)	N			
15	Update QSI 020 (TC/FAA STC) and/or STC Approval List	N			
16	Create/Update Parts / STC Database	Y	MG		<i>met 20.02.18</i>
17	Update / Verify Authorized Release Certificate Database	N			
18	Create / Update Change Record Form / Item Card Database	N		NO TOP LEVELS AT THIS RELEASE	
19	Create / Update Packaging Process Plan (PPP)	N			
20	Red Decals required on Packaging Process Plan (PPP)?	N			
21	Update Controlled Supplier Documents (Qpulse) Database	Y	MG	<i>No dwgs at suppliers</i>	<i>met 20.02.18</i>
22	Update Grey Project Folder / Electronic Project Folder	N			
23	Update D-Part / M-Drawing / DSI / DEO Master Binders	Y	MG		<i>met 20.02.18</i>
24	Update "Royalty Paid to" attribute (Parts sold under Dart USA STC's)	N			
25					

Description / Action:
Releasing first batch of D350-1080 basket drawing updates for production under Limited Release per QSI 040.
Place all parts under review. Engineering to sign off work orders for on risk production
No STC for these parts at this time
No nine digit BOMS/ROUTES/CHG#S for this release
Previous Parts Satisfactory for M Drawing updates. M Drawings not under Review

ECN Verified & Complete: _____ Date: _____